

**Work Order ID 74617**

Monday, October 03, 2011 4:06:29 PM



Page 1

Item ID: D3537-7

Accept



Setup

Start



Revision ID:

Item Name: Wearpad

Stop



Start Date: 10/3/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 10/5/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: M.L.5

Date: \ \ / \ / \ / \ /

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run

Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr	Revision Nbr
D3537	Rev C

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

B11-10-4

FLOW CNC Waterjet

304 .0031-Cut as per Dwg D3537  Dwg Rev: C  Prog Rev: C  2-  
Deburr if necessary(12)

110

QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

B11-10-4

Quality Control

120

QC8- Inspect parts - second check

0.00



Memo

0.00

Sukholos(12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 74617**

Monday, October 03, 2011 4:06:29 PM



Page 2

Item ID: D3537-7

Accept



Setup Start



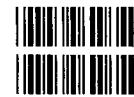
Revision ID:

Item Name: Wearpad

Stop



Start Date: 10/3/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 10/5/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130



NC BRAKE

0.00

(12)

Brake NC

Memo

0.00

Brake NC

Deburr if necessary  Form on Brake as per Dwg D3537 using Jigs DT8261 and DT8326.

SB 11/01/11

140



QC5- Inspect part completeness to step on W/O

0.00

S ualot u

QC

Quality Control

Memo

0.00

(12)

Ensure joggle as per dwg D3429

150



Large Fab

0.00

X12 11-01-01 JL

Large Fab

Memo

0.00

Qty Description Batch A/R  
0 Weld hardcoat as per Dwg D3437

2059B Hardcoat

m 11906)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 74617**

Monday, October 03, 2011 4:06:29 PM



Page 3

Item ID: D3537-7

Accept



Setup Start



Revision ID:

Item Name: Wearpad

Stop



Start Date: 10/3/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 10/5/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160



QC10- Inspect visual per QSI004- ground welds

0.00

*PL111110*
*10x* *10*

QC

Quality Control

170



QC5- Inspect part completeness to step on W/O

0.00

*11/11/11* *12*

QC

Quality Control

180



Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

Memo

*3:45*

0.00

*10x 10 11/11/11*

Powdercoat

Powder Coating

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

*4:15*
*M118439 320°F*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 74617**

Monday, October 03, 2011 4:06:29 PM



Page 4

**Item ID:** D3537-7**Accept****Setup****Start****Revision ID:****Item Name:** Wearpad**Stop****Start Date:** 10/3/2011 **Start Qty:** 10.00**Cust Item ID:****Required Date:** 10/5/2011 **Req'd Qty:** 10.00**Customer:****Reference:****Approvals:****Process Plan:****Date:****Tooling:****Date:****Run****Start****QC:****Date:****SPC (Y/N):****Date:****Stop****Sequence ID/  
Work Center ID****Operation  
Description**

190

QC3- Inspect Part Finish



QC

Quality Control

**Set Up/  
Run Hours****Tool ID****Tool #****Plan  
Code****Accept  
Qty****Reject  
Qty****Reject  
Number****Insp.  
Stamp**

200

Identify as per dwg & Stock Location: FP-1

0.00

12

BR 11-11-2

Packaging

Packaging

**Memo**

0.00

12

BR 11-11-2

210



QC21- Final Inspection - Work Order Release

0.00

QC

Quality Control

**Memo**

0.00

11/11/02 JJ

11/11/02  
(12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

Page 1

Monday, October 03, 2011 4:06:36 PM

Work Order ID: 74617



Parent Item: D3537-7



Parent Item Name: Wearpad

Start Date: 10/3/2011

Required Date: 10/5/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A New Issue 07-03-12 ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA 		Purchased		No		100	sf	112.1300	0.15	1.578947		B11-10-7	

304/316 Sheet .063

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT020	112.13	
118578	16.13	
118964	96	

118578

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	74617
Description: Wearpad	Part Number:	D3537-7
Inspection Dwg: D3537	Rev: C	Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

Measured by: <u>B</u>	Audited by: <u>S</u>	Prototype Approval: N/A
Date: 11-10-4	Date: 11/10/05	Date: N/A

Rev	Date	Change	Revised by	Approved
A	07.03.21	New Issue	KJ/JLM	
B	07.04.30	Dimensions updated per Dwg Rev B	KJ/JLM	
C	07.06.04	Dwg Rev updated to C	KJ/JLM	<i>BB</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

SHOP COPY  
RETURN TO  
ENGINEERING

UNCONTROLLED COPY  
SUBJECT TO AMENDMENT

WITHOUT NOTICE  
WORK ORDER  
NO. 74617

SECTION A-A  
R1.62  
M.L.J  
11/10/04  
0.9

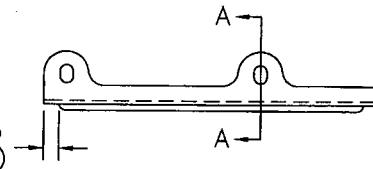
APPLY 2 LAYERS OF  
2059B HARDCOAT WELDS  
TO WITHIN 0.25 OF  
WEARPAD ENDS  
0.188 TO 0.250 THICK

SECTION B-B

R1.62  
0.12 (TYP)  
0.130  
0.100  
D2941-300  
REMOVE POWDER  
COAT FROM THESE  
SURFACES

RELEASED  
07.05.08 AH  
per ECN  
962

D3537-7 LONGITUDINAL BEND  
(MADE FROM D3537-3F)



D3537-1/-3/-5/-7 WEARPAD NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)  
(REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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DART AEROSPACE USA, INC.

DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA
C	07.04.13	WIDEN TAB TO 0.380, WELD PATTERN
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.11.06	NEW ISSUE
CB	PH	
CHECKED	APPROVED	DRAWING NO. REV. C
		D3537 SHEET 1 OF 1
DATE		TITLE
07.04.13		WEARPAD
		SCALE
		1:2

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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